

Work Order ID 71886

Wednesday, July 13, 2011 11:09:36 AM



Page 1

Item ID: D3063-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 7/14/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan: *CMF*

Date: *11-07-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3063

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blanks 4.000" x 2.500" x 0.625" thick

B.K. 11/07/26 60 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA175 and Dwg D3063
2-Debur & Tumble

Issue P.O. 14572
Dan's Precision
Machine per drawing D3063 Rev.A

u 11.08.24

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Receive & Inspect for transit damage
Ensure C of C attached

Rec'd 9/9 (60)

RKG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71886

Wednesday, July 13, 2011 11:09:36 AM



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Item ID: D3063-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 7/14/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8/Inspect parts - second check

0.00

Memo

0.00

Sulzor

count
160

140



Packaging

Packaging -

Identify as per dwg & Stock Location: *WA*

0.00

Memo

0.00

*** STOCK IN STEP CELL***

11-09-09

60 *φ*

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/12

ME
11-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

Wednesday, July 13, 2011 11:09:34 AM

Page 1

Work Order ID: 71886

Parent Item: D3063-1

Parent Item Name: Support



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: ☐C☐02.10.04☐Re-format; Blank size change☐KJ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.625X02.50 0		Purchased	No			100	f	9.8300	0.3417	10.79053			



6061-T6 Bar .625 x 2.50



F.K - 11/07/26.

Location

MAT002

114351

116963

118400

Loc Qty

9.83

0.83

9

Loc Code

0.33

9.00

10.66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

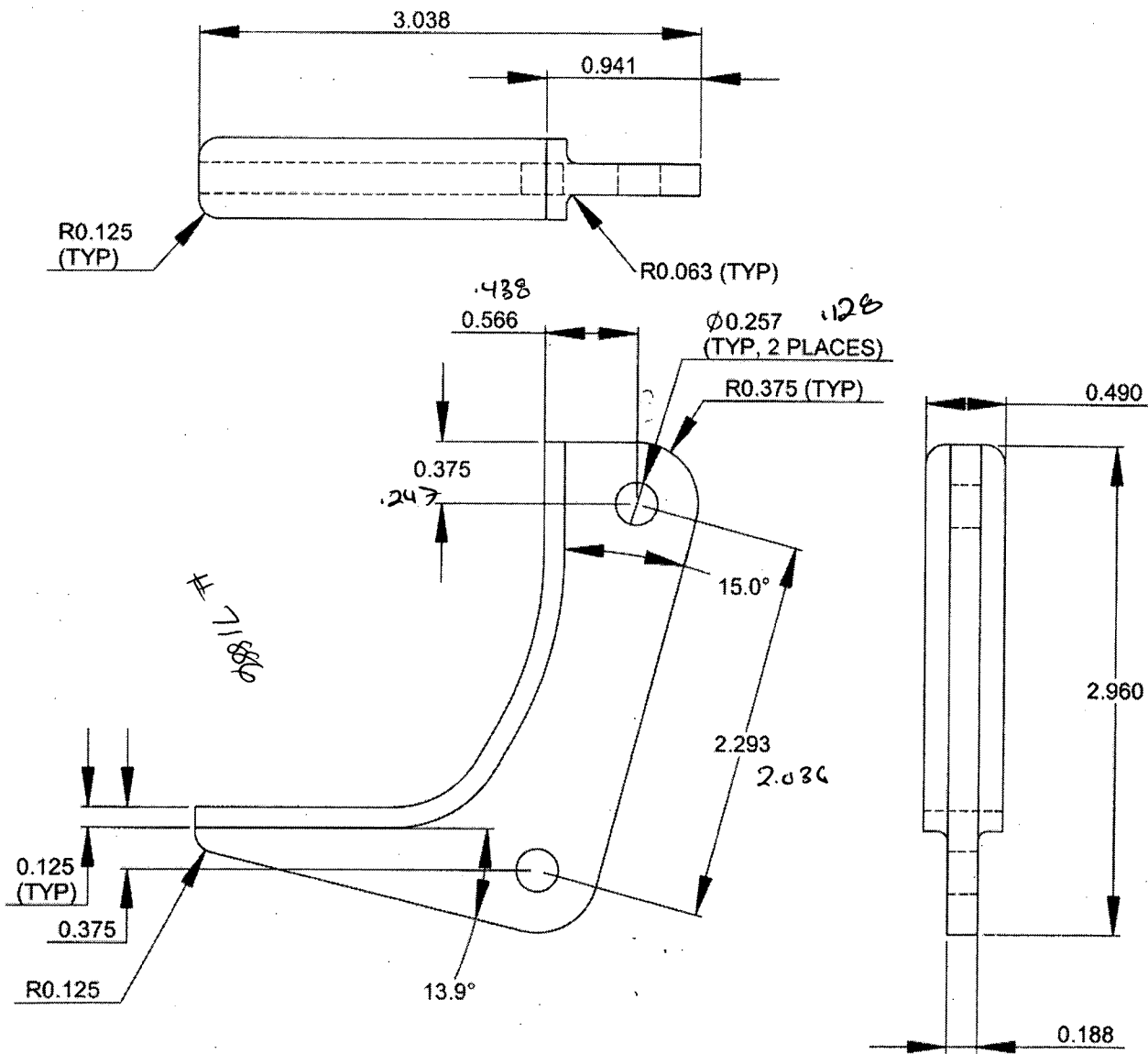
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3063	REV. A SHEET 1 OF 1
DATE 02.09.10		TITLE SUPPORT	SCALE 1:1
A	02.09.10	NEW ISSUE	

RELEASED
02.09.2010



D3063-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3063-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A-3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

PACKING SLIP

Ship To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Number: 10722

Date: September 08, 2011

Customer's Order: PO14572

Item#	Line#	Qty	Part #	Description	Status
1	4	60	D3063revA	Support	Complete

Number of Packages:

☐ Boxes _____

☐ Bags _____

☐ Bundles _____

Received by: _____ Date: _____

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 08-Sep-11

Purchase Order : PO14572

Packing Slip : 10722

Part Number : D3063revA

Quantity : 60

Subtotal

Per: _____

For Dan's Precision Tools Inc.

Work Order ID 76152***76152***

Page 1

November-08-11 10:46:17 AM

Item ID: D3063-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 11/08/11 Start Qty: 60.00

60

Cust Item ID:

Required Date: 11/08/11 Req'd Qty: 60.00

60

Customer:

Reference: to correct costing

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3063

Rev A

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

to pull purchased part to correct costing

W 11.11.08

Picklist Print

November-08-11 10:46:17 AM

Page 1

Work Order ID: 76152

Parent Item: D3063-1

Parent Item Name: Support

Start Date: 11/08/11

Required Date: 11/08/11

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: C02.10.04Re-format; Blank size changeKJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3063-1 Support		Manufactured	No				Each	78.0000		60			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		78							
				66182		18							
				71886		60							
D3063-1P Support		Purchased	No				Each	0.0000		60			

Item ID	Trans Type	Trans Date	Inv Change An Reference	
D3063-1	Startup LOC Tracking	12/05/09 18:34	0	
D3063-1	Account Value Change	12/05/09 18:34	0 Old value 0	
D3063-1	Account Value Change	12/05/09 18:34	0 New value 29.3683	
D3063-1	Inv Adjustment	12/05/09 18:34	969.1539 Item Revision Consolidation Automation; Acct#: 60100-50; Emp ID: INS007	
D3063-1	Issue	12/15/09 11:28	-117.4732 Work Order ID: 54192, Reason: , Employee ID: DCUSER	
D3063-1	Issue	12/18/09 13:41	-117.4732 Work Order ID: 54193, Reason: , Employee ID: GOLD01	
D3063-1	Account Value Change	2/16/10 14:59	-0.0525 29.37 -> 29.37	
D3063-1	Issue	2/17/10 10:25	-29.3662 Work Order ID: 56227, Reason: , Employee ID: DCUSER	
D3063-1	Issue	2/17/10 10:26	-29.3662 Work Order ID: 56226, Reason: , Employee ID: DCUSER	
D3063-1	Issue	2/22/10 11:07	-29.3662 Work Order ID: 56372, Reason: , Employee ID: DCUSER	
D3063-1	Issue	3/17/10 9:25	-29.3662 Work Order ID: 57012, Reason: , Employee ID: DCUSER	
D3063-1	Loc Transfer	3/18/10 17:09	616.6902	
D3063-1	Loc Transfer	3/18/10 17:09	-616.6902	
D3063-1	Issue	3/24/10 10:35	-146.831 Work Order ID: 56918, Reason: , Employee ID: DCUSER	
D3063-1	Issue	4/08/10 12:46	-117.4648 Work Order ID: 57399, Reason: , Employee ID: DCUSER	
D3063-1	Account Value Change	4/27/10 12:34	5.2512 29.37 -> 29.80	
D3063-1	Issue	6/11/10 10:09	-119.2152 Work Order ID: 59355, Reason: , Employee ID: DCUSER	
D3063-1	Issue	6/11/10 12:30	-59.6076 Work Order ID: 58788, Reason: , Employee ID: DCUSER	
D3063-1	Issue	6/11/10 12:34	-119.2152 Work Order ID: 59360, Reason: , Employee ID: DCUSER	
D3063-1	Account Value Change	6/18/10 10:59	0 Old value 29.8038	
D3063-1	Account Value Change	6/18/10 10:59	0 New value 16.0446	
D3063-1	WIP Receipt	6/18/10 10:59	641.784 Work Order ID: 59663, Employee ID: FAUT01	
D3063-1	Lot Maintenance	6/21/10 11:04	0	6/21/10 11:04
D3063-1	Account Value Change	7/29/10 11:35	0.0042 16.04 -> 16.04	
D3063-1	Issue	8/05/10 9:02	-32.0894 Work Order ID: 60618, Reason: , Employee ID: DESJ02	
D3063-1	Issue	8/05/10 9:26	-32.0894 Work Order ID: 60619, Reason: , Employee ID: DESJ02	
D3063-1	Issue	10/12/10 10:08	-32.0894 Work Order ID: 61904, Reason: , Employee ID: DCUSER	
D3063-1	Issue	11/02/10 11:04	-64.1788 Work Order ID: 63094, Reason: , Employee ID: DCUSER	
D3063-1	Issue	11/02/10 11:08	-64.1788 Work Order ID: 63095, Reason: , Employee ID: DCUSER	
D3063-1	Issue	11/10/10 14:29	-48.1341 Work Order ID: 62556, Reason: , Employee ID: DCUSER	
D3063-1	Issue	11/10/10 16:56	-48.1341 Work Order ID: 62557, Reason: , Employee ID: DCUSER	
D3063-1	Issue	2/12/11 17:33	-64.1788 Work Order ID: 65810, Reason: , Employee ID: DCUSER	
D3063-1	Issue	2/12/11 17:38	-64.1788 Work Order ID: 65809, Reason: , Employee ID: DCUSER	

D3063-1	Loc Transfer	3/11/11 13:40	224.6258	
D3063-1	Loc Transfer	3/11/11 13:40	-224.6258	
D3063-1	Account Value Change	3/31/11 8:33	0 Old value 16.0447	
D3063-1	Account Value Change	3/31/11 8:33	0 New value 16.3604	
D3063-1	WIP Receipt	3/31/11 8:33	327.208 Work Order ID: 66182, Employee ID: FAUT01	
D3063-1	Lot Maintenance	3/31/11 10:09	0	3/31/11 10:08
D3063-1	Issue	7/07/11 17:30	-65.4416 Work Order ID: 70561, Reason: , Employee ID: DCUSER	
D3063-1	Issue	7/07/11 17:53	-65.4416 Work Order ID: 70562, Reason: , Employee ID: DCUSER	
D3063-1	Issue	7/13/11 19:23	-65.4416 Work Order ID: 68689, Reason: , Employee ID: DCUSER	
D3063-1	Issue	7/13/11 19:30	-65.4416 Work Order ID: 68690, Reason: , Employee ID: DCUSER	
D3063-1	Account Value Change	9/09/11 11:54	0 Old value 16.3604	
D3063-1	Account Value Change	9/09/11 11:54	0 New value 6.1937	
D3063-1	WIP Receipt	9/09/11 11:54	371.622 Work Order ID: 71886, Employee ID: FAUT01	
D3063-1	Lot Maintenance	9/12/11 14:11	0	9/12/11 14:11
D3063-1	Rework	11/08/11 10:44	-371.622 Rework ID: 76152, Reason: , Employee ID: LACE01	
D3063-1	Account Value Change	11/08/11 10:46	0 Old value 6.1937	
D3063-1	Account Value Change	11/08/11 10:46	0 New value 30.0399	
D3063-1	WIP Receipt	11/08/11 10:46	1802.394 Work Order ID: 76152, Employee ID: LACE01	